

Date: Tuesday, 06/03/2007 2:29:40 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : NUT PLATE
Job Number : 30837	
Estimate Number : 11262	
P.O. Number : N/A	Part Number : D3415041
This Issue : 06/03/2007 S.O. No. : N/A	Drawing Number : D3415 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 31027	Material : N/A
Written By : _____	Due Date : 13/03/2007 Qty: 20 Um: Each
Checked & Approved By : _____	
Comment : Est: A 05.10.03 New issue KJ/JLM	
Est Rev:B Now on Waterjet 07-03-06 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S16GA	304/316 .063 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.0138 sf(s)/Unit Total: 0.2751 sf(s)
 304/316 .063 Sheet
 Batch: M101463 ml 07 03 07

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3415
 Dwg Rev: B
 Prog Rev: B

ml 07 03 07

(20)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07 03 07

(20)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

07/03/07 (20)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr SAD 07/03/12
 2-C'sink as per Dwg D3415 ml 07/03/14 x 20

Date: Tuesday, 06/03/2007 2:29:40 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 30837

Part Number: D3415041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



M 103706



(20)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-l

07/03/15

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf

07-03-19

(20)

8.0 MS21070L4

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut Plate

Pick:

Qty Part Number Description Batch

1 MS21070L4 Nut Plate

M103925 x 7mx

M100857 x 13mx

07-03-19

9.0 MS20043003

MS20427F3-3

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 40.0000 Each(s)

RIVET

Batch: M18855

mf

07-03-19

(P10) →

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut plate as per Dwg D3415

mf

07-03-27

mf

07-03-19

(7) (20) (15)

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JB 07/03/27

20

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/3/28 (20)

Date: Tuesday, 06/03/2007 2:29:41 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 30837

Part Number: D3415041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

06/03/29

Job Completion



CU 06/03/29

(P10)
→

Date: Thursday, 2/22/2007 2:58:59 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : NUT PLATE
Job Number : 30837	
Estimate Number : 11262	
P.O. Number :	Part Number : D3415041
This Issue : 2/22/2007 S.O. No. :	Drawing Number : D3415 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 26776	Material :
Written By :	Due Date : 3/13/2007 Qty: 20 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est: A 05.10.03 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: _____

Email or Ship DXF file to vendor

Laser Cut D3415-1 flat pattern as per Dwg D3415

Possible Supplier: Industrial Laser

Material release note is required

*M3035166A
0.013 SF*

[Handwritten signature]

2.0	D34151F	Lug Bracket
-----	---------	-------------



Comment: Qty.: 1.0000 U(s)/Unit Total : 10.0000 U(s)

Lug Bracket

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

2-C'sink as per Dwg D3415

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
070314	9.0	Make change to MS20427 F3-3 As per previous W/O's for the Eng's Estimates.	<i>[Signature]</i>	070714		<i>[Signature]</i> 070314	<i>[Signature]</i> 070314

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:58:59 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 30837

Part Number: D3415041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

MS21070L4

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut Plate

Pick:

Qty Part Number Description Batch

1 MS21070L4 Nut Plate

9.0

MS206133C3

RIVET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

RIVET

Batch: _____

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut plate as per Dwg D3415

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/22/2007 2:58:59 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 30837

Part Number: D3415041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

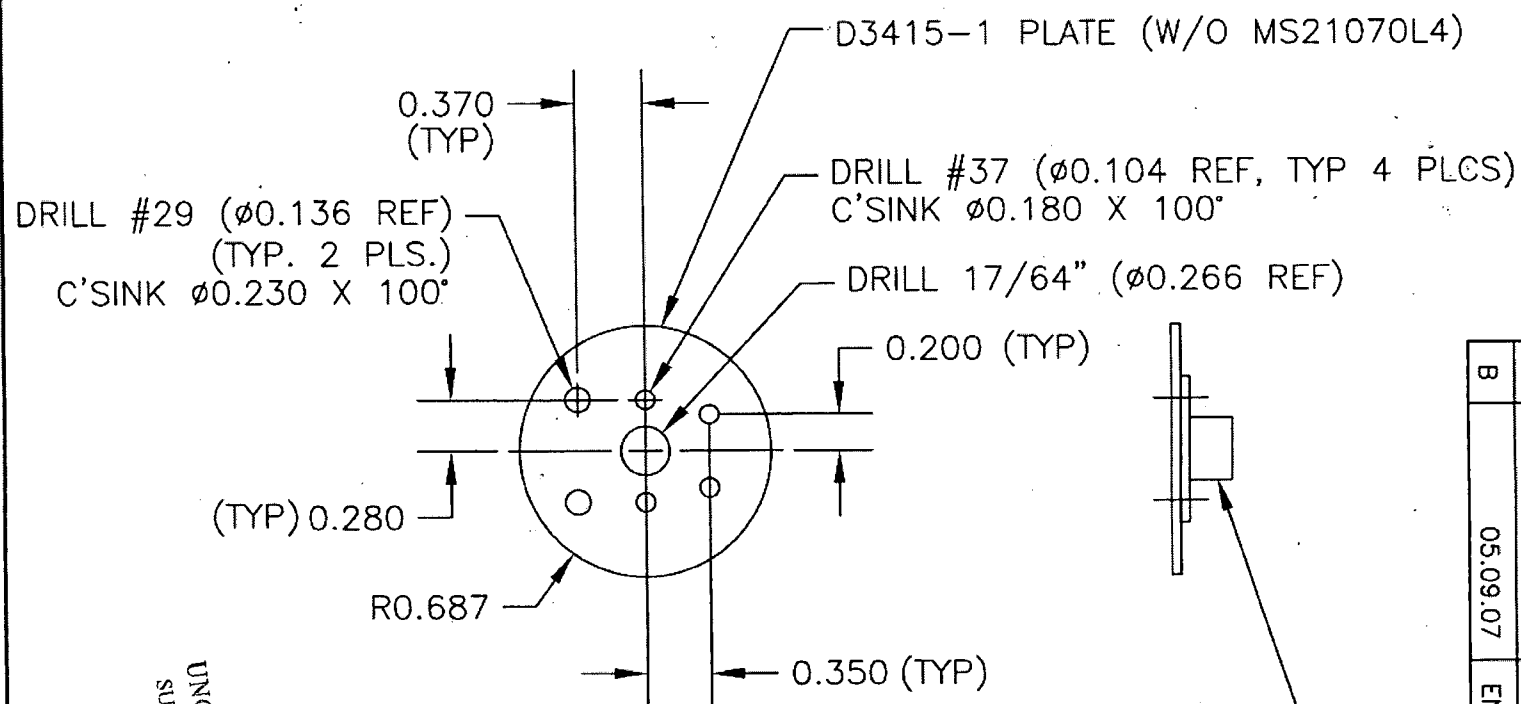
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CP	CP	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3415	SHEET 1 OF 1
DATE	TITLE	SCALE	
05.09.07	NUT PLATE	1:1	
A	05.03.16	NEW ISSUE	
B	05.09.07	ENLARGE ALL HOLES FOR POWDER COAT	

RELEASED
05 09 09 - 11



MS21070L4 NUT PLATE (1)
INSTALL WITH ~~MS20613-3C3~~ RIVETS (2)
H20427 F3-3 rivet (2)
[Signature] 0703-14

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
NO. *[Signature]* 30837

D3415-041 NUT PLATE

- 1) MATERIAL: AISI 304 SS SHEET, 0.063 THICK (16 GAUGE, REF DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

